

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020589**Date Inspected:** 09-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1100**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Chanxing Island**Location:** Shanghai, China**CWI Name:** Mr. Qui Wen**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA), Vibin Kumar Selvanayaham, was present during the times noted above for observations relative to the work being performed.

Ultrasonic Testing (UT) – NWIT Document No: 008322

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as OBG Segment 13AE. The weld designations reviewed are as follows:

1. SEG3007P-260, 255, 227, 233, 238, 243, 248, 253, 263, 258

Bay 14

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) welding of weld joint SEG3014F-005 located on Deck Panel Diaphragm to Floor Beam at panel point 121.5 of OBG Segment 13BW. ZPMC Welders are identified as 066695 and 201583. ZPMC Quality Control (QC) is identified as Mr. Qiu Wen. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2232-ESAB.

FCAW welding of weld joint SEG3014H-235 located on Deck Panel Diaphragm to Floor Beam at panel point 120.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

5 of OBG Segment 1BCW. ZPMC Welders are identified as 045227 and 067888. ZPMC Quality Control (QC) is identified as Mr. Qiu Wen. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2232-ESAB.

Shielded Metal Arc Welding (SMAW) repair welding of weld joint SEG3020E-044 located on Floor Beam to Longitudinal Diaphragm at panel point 128.3 of OBG Segment 14W. ZPMC Welder is identified as 066038. ZPMC Quality Control (QC) is identified as Mr. Wang Xiang Pin. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-3G (3F) – FCM – Repair, which is used as per Critical Welding Repair (CWR) B-CWR-2735.

SMAW welding of weld joint SEG3020D-062 located on Floor Beam to Edge Beam at panel point 128.3 of OBG Segment 14W. ZPMC Welder is identified as 069683. ZPMC Quality Control (QC) is identified as Mr. Wang Xiang Pin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-Tc-U4b-FCM.

FCAW welding of weld joint SEG3020V-070 located on Longitudinal Diaphragm Stiffener of OBG Segment 14W. ZPMC Welder is identified as 067760. ZPMC Quality Control (QC) is identified as Mr. Wang Xiang Pin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2232-ESAB.

FCAW welding of weld joint SEG3020AB-054 located on Longitudinal Diaphragm to Floor Beam at panel point 128 of OBG Segment 14W. ZPMC Welder is identified as 067949. ZPMC Quality Control (QC) is identified as Mr. Wang Xiang Pin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2232-ESAB.

SMAW welding of weld joint DP3173-001-019 located on Deck Panel to Deck Panel Diaphragm of OBG Segment 14W. ZPMC Welder is identified as 037779. ABF Quality Control (QC) is identified as Mr. Shen Jian. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2212-Tc-U4b-FCM-1.

SMAW welding of weld joint DP3174-001-018 and 020 located on Deck Panel to Deck Panel Diaphragm of OBG Segment 14W. ZPMC Welders are identified as 066155 and 037780. ABF Quality Control (QC) is identified as Mr. Shen Jian. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2212-Tc-U4b-FCM-1.

Bay 16

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) welding of weld joint SEG3095-001-017 and 018 located on Bottom Plate of OBG Segment 14E. ZPMC Welder is identified as 068858. ZPMC Quality Control (QC) is identified as Mr. Guo Xing Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2132-ESAB. See the attached picture.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Vibin	Quality Assurance Inspector
Reviewed By:	Patel,Hiranch	QA Reviewer
